



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200
Fax 613 632-5246

RBT18538-3
Job Sheet 186665



Part No: RBT18538-3

Job Qty: 10 ea

Part Name: Right Seat Brace



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/4/18

Created By: Marie Lajeunesse

Type: ~~SOLD~~

Description:

Note: DWG RBT18538 Rev2A IPP Rev A 17.12.13 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs	12/4/18	12/4/18	0.00	1.00	Waterjet - Flow		SE 18/12/18
110	QC	10 pcs	12/4/18	12/4/18	0.00	0.00	QC2 Waterjet-4		SE 18/12/18
120	QC	10 pcs	12/4/18	12/4/18	0.00	0.00	QC8-7		38 68-6
130	Brake NC	10 pcs	12/4/18	12/4/18	0.00	2.50	Brake NC 1		DAS 0-80 0E
140	QC	10 pcs	12/4/18	12/4/18	0.00	0.00	QC5		DAS 0-80 0E
150	Outsource	10 pcs	12/4/18	12/4/18			ATG001-VC	5	40 9-89 0E
160	Packaging	10 pcs	12/4/18	12/4/18	0.00	0.00	Packaging2		9-89 0E
170	QC	10 pcs	12/4/18	12/4/18	0.00	0.00	QC6		9-89 0E
180	Packaging	10 pcs	12/4/18	12/4/18	0.00	0.00	Packaging3-1		28 9-89 0E
190	QC21-SA	10 Ea	12/4/18	12/4/18	0.00	0.00	QC21		9-89 0E

Part Op 100 - 1-Cut as per Dwg (RED BARN FOLDER) Dwg Rev: A2 Prog Rev: A2 2-Deburr if necessary

Descriptions: 130 - Form as per DWG sheet 2

140 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

150 - Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.040	5052-H32 .040 Sheet	3.6000 sf (.36 ea)	100-Waterjet - Flow - 1	5099478

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M5052H32S.040	4	34	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				Engineering	
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Other	☐

Date : _____ Step #: _____

Description Work Order De

DART AEROSPACE
 Container No: S135006
 Part: RBT18538-3
 Job No: 186665
 Serial No/Batch: S135006
 Revision: 2A
 Inspector:
 Exp Date:
 Instructions:
 Date: 12/05/18

ARB (QSI042) Approval

Completed By

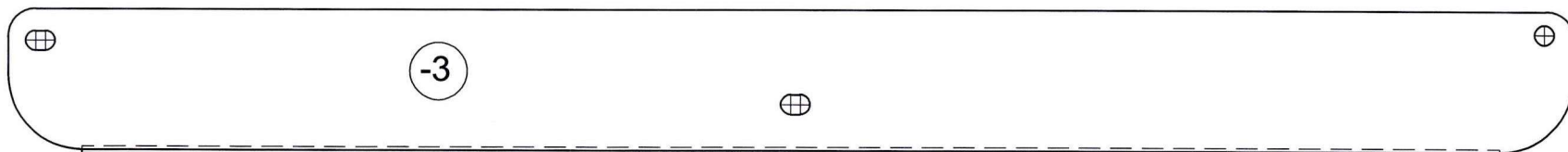
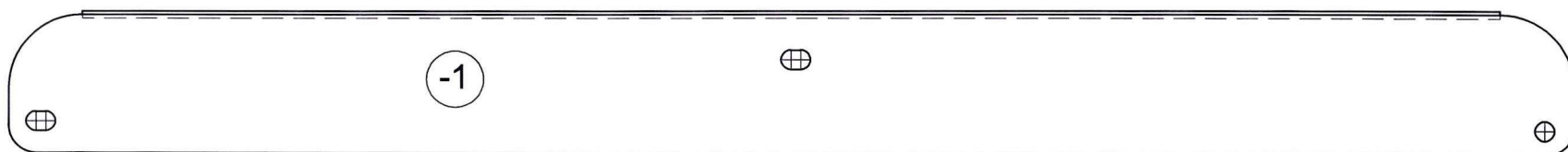
Hand / Supervisor
Approval Verification

QA Coordinator
Approval

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/F	☐	Power Loss/Surge	☐
Design	☐	Operator	☐	Bending	☐	Power/Program	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not	☐	Weld	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Wrong Stock Pulled	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/I	☐	Out of Sequence	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Off-set	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Mislabeled	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Fit/Function	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Misaligned/off center	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Positioned Wrong	☐
Past Expiry Date	☐	Manufacturing Process	☐	Inspection Incomplete/Unqualified	☐	Outside Dimensions	☐
Misidentified	☐	Past Due	☐	Contamination	☐	Over/Under tolerance	☐
				Countersink	☐	Part Incorrect	☐
				Cut Too Short	☐	Part Lost/Missing	☐
				Instructions Incomplete/Unclear	☐	Part Moved	☐
				Drill Holes	☐	Drawing	☐
						Finish	☐
						Misread	☐
						Turning Sequence	☐
				OTHER :			

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ORIGINAL TOOL WAS A MACHINED SOLID PART, NOW A FORMED PART.	10/7/10	WP	
2	CH'D MATERIAL THICKNESS FROM .06 TO .04, CH'D CUT OUTS ON END FROM .75 TO .83 (x2), CH'D R.31 (x4) TO R.31 (x2), & ADDED R.83 (x2), CH'D TWO Ø.218 HOLES TO ELONGATED SLOTS, ADDED R.125 (x2) TO LIP PER D.W.	1/6/11	RJC	
2A	ADDED ENGRAVE NOTE -1 & -3 PER R.W.	2/17/11	RJC	RW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186665 MCL
18-11-20

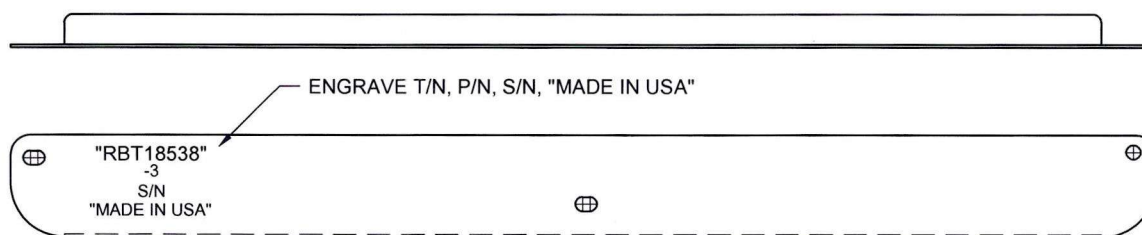
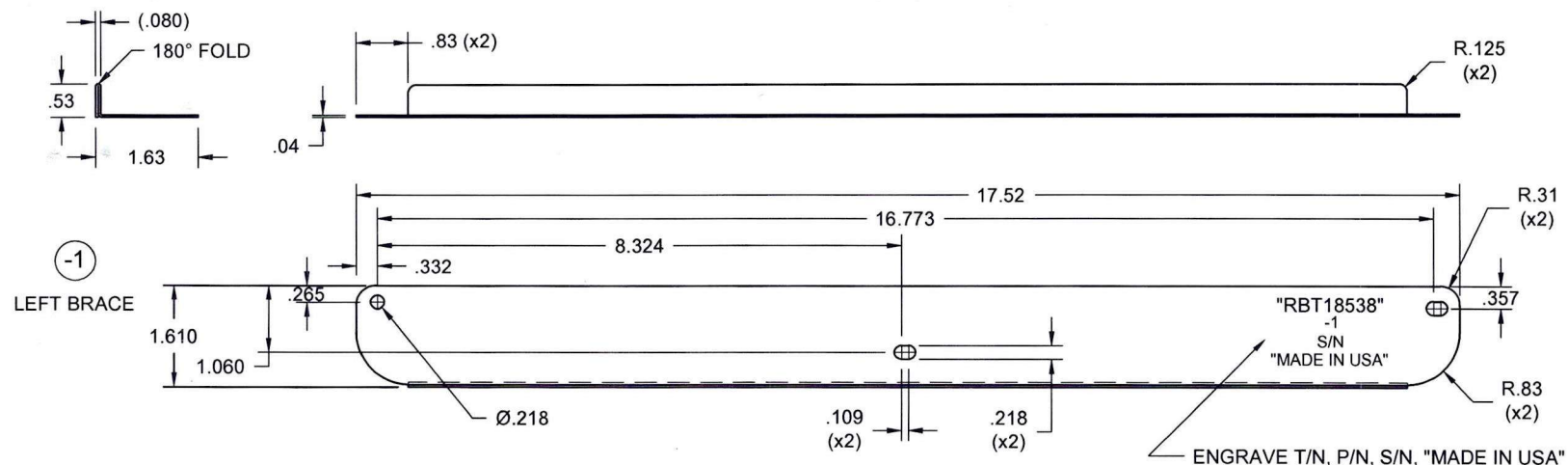
Added B & L & 407 to used on
model 3/20/12 after DW veified
the hole pattern is the same.
No rev done. RJC

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	LEFT SEAT BRACE	5052	.040 x 2-3/4 x 17-5/8	2
			-3	1	RIGHT SEAT BRACE	5052	.040 x 2-3/4 x 17-5/8	2

RED BARN MACHINE	
TITLE SEAT FRAME SUPPORTS	
DWG NO. RBT18538	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 METRIC REF. .XXmm ± .1mm .XX ± .01 FRACTIONS ± 1/32 .X ± .1 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT APPROVED: D. Weid HEAT TREAT FINISH SPEC USED ON MODEL BELL 206 B & L, 407	
SCALE NTS	DATE 10-7-10
SHEET 1 of 2	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
2	CH'D MATERIAL THICKNESS FROM .06 TO .04, CH'D CUT OUTS ON END FROM .75 TO .83 (x2), CH'D R.31 (x4) TO R.31 (x2), & ADDED R.83 (x2), CH'D TWO Ø.218 HOLES TO ELONGATED SLOTS, ADDED R.125 (x2) TO LIP PER D.W.	1/6/11	RJC
2A	ADDED ENGRAVE NOTE -1 & -3 PER R.W.	2/17/11	RJC RW



-3
RIGHT BRACE
(DIMENSIONALLY OPPOSITE LEFT BRACE)

RED BARN MACHINE	
TITLE SEAT FRAME SUPPORTS	
DWG NO. RBT18538	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XX ± .005 FRACTIONS 1/32 ANGLES ± 5° METRIC REF. .XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT APPROVED: <i>D. Weir</i> HEAT TREAT: FINISH: CLEAR ANODIZE SPEC: MIL-A-8625F, TYPE II, CLASS I USED ON MODEL: BELL 206 B & L, 407	SCALE: NTS DATE: 10-7-10 SHEET: 2 of 2



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042839



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042839

PO Date: 3/8/19

Due Date: 3/15/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191260	HT-900-NC-09A	Filter Base Outsource4 (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to GROUPE ALTECH PO: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed - X4		3/15/19	4 pcs	0 pcs	4 pcs	\$3.72/pcs	\$14.88

MAR 14 2019

DP

Line Item Note **Need back for March 15,2019**



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PURCHASE ORDER

PO042839



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	189092	RBT18538-1	Left Seat Brace -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed - X21		3/15/19	21 pcs	0 pcs	21 pcs	\$3.72/pcs	\$78.12
MAR 15 2019 DP											
Line Item Note **Need back for March 15,2019**											
3	186665	RBT18538-3	Right Seat Brace -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed - X10		3/15/19	10 pcs	0 pcs	10 pcs	\$3.72/pcs	\$37.20
MAR 15 2019 DP											
Line Item Note **Need back for March 15,2019**											
4	189093	RBT18538-3	Right Seat Brace -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed - X9		3/15/19	9 pcs	0 pcs	9 pcs	\$3.72/pcs	\$33.48
MAR 15 2019 DP											
Line Item Note **Need back for March 15,2019**											



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PURCHASE ORDER

PO042839



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	R190195	C2-1-1	Manual Release Knob (Outsource process- Anodize per QSI017 4.1.10.1)-Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed -		3/15/19	5 pcs	0 pcs	5 pcs	\$3.72/pcs	\$18.60
Line Item Note **Need back for March 15,2019** X5 MAK 15 2019 DP											
6	R190194	4.5NR-32	Manual Release Knob RED ANODIZE PER MIL-A- 8625 TY II CL 2	Firmed -		3/15/19	22 pcs	0 pcs	22 pcs	\$3.72/pcs	\$81.84
Line Item Note **Need back for March 15,2019** X22 MAR 15 2019 DP											
7	186714	646.3012	Lower Guide Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3000	Firmed -		3/15/19	4 pcs	0 pcs	4 pcs	\$21.32/pcs	\$85.28
Line Item Note **Need back for March 15,2019**											
8	187494	646.3012	Lower Guide Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3000	Firmed -		3/15/19	8 pcs	0 pcs	8 pcs	\$21.32/pcs	\$170.56
Line Item Note **Need back for March 15,2019**											



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PURCHASE ORDER

PO042839



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	190533	RBW109-3130-34-1-1	Cylinder, Ø2-5/8 X 4-1/2 -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/15/19	5 pcs	0 pcs	5 pcs	\$3.72/pcs	\$18.60

XS

MAR 14 2019

DP

Line Item Note **Need back for March 15,2019**

Grand Total: \$538.56

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/14/19 3:07 PM dart.Lussier.Patrick



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917447

Date: 14-Mar-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
1 each	Part: HT-900-NC-09A Filter Base Anodize per MIL-A-8625F, Type II, Class 2, Black, Water Sealant .0004-.0010" (.4 - 1 mils). Job: 24753	Rev: 6E PO: PO042839	Line: 1
21 ea	Part: RBT18538-1 Left Seat Brace Clear Anodize per MIL-A-8625F, Type II, Class 1, Clear .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24754	Rev: 2A PO: PO042839	Line: 2
19 ea	Part: RBT18538-3 Right Seat Brace Clear Anodize per MIL-A-8625F, Type II, Class 1, Clear .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24755	Rev: 2A PO: PO042839	Line: 3-4
5 each	Part: C2-1-1 Manual Release Knob Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils) Water Sealant Job: 24756	Rev: PO: PO042839	Line: 5
22 each	Part: 4.5NR-32 Manual Release Knob Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils) Water Sealant Job: 24757	Rev: 1 PO: PO042839	Line: 6
5 ea	Part: RBW109-3130-34-1-1 Cylinder, Ø2-5/8 x 4-1/2	Rev:	
Made in Canada.			

Made in Canada.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917447

Date: 14-Mar-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (4 - 1 mils) Job: 24759 PO: PO042839 Line: 9		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>14/3/19</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			